

Date: Monday, 6/5/2006 7:48:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 27379		Part Number	: D314097	
Estimate Number	: 11468		Drawing Number	: D3140 REV D1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: D1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2006 Qty: 4 Um: Each	
Previous Run	: 26724				
Written By	<u>See ff comments below</u>				
Checked & Approved By	<u>ff 06.06.06 N</u>				
Comment	: Est. A02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC				

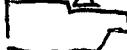
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet Comment: Qty.: 0.1796 sf(s)/Unit Total : 0.7182 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 (QQ-A-250/4) .032" thick (M2024T3S.032) Batch <u>1100284</u> <u>11 06 08</u>
2.0	SHEAR	SHEAR Comment: SHEAR Cut blanks Blank size: 3.810" x 6.43" x .032" thick Grain along 3.810"
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folt FA226 Stack of 10 Deburn break all unmarked sharp edges .005 to .010 Form as per dwg (-97 shown) <u>Waterjet</u> <u>Dwg Rev P1</u> <u>Prog Rev D1</u> <u>11 06 06 07 01</u>
4.0	<u>.005 QC2</u>	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP <u>11 06 06 08 01</u> <u>4.1 QC8 Second check.</u> <u>11 06 12</u> <u>EP</u> <u>PRO</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
6-06-12	B	I Part cut crooked across top section, at Piercing point. Part unacceptable. 	J	Scrap - destroy. Took 1 from - 97 for bonding.	/ / 06/06/12	Z	Z	Z

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 DQA: 

Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 6/5/2006 7:48:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27379

Part Number: D314097

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/06/14

(4)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SB 06/06/14

(9)

8.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/15

U 06-06-1

(4)

Job Completion



4.2 Small FAB.
Form as per Day 3190.

SB 06/06/13

(5)

4.3. QCS 20-06-13 (5)

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
D1	<i>[initials] 06.03.31</i>	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED
05.12.01 *[initials]*

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
				1	X	D3140-09	DOUBLER ASSEMBLY
					1	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
			1			D3140-91	DOUBLER
				1		D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
1						D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
				1		D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
		1	1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET
							SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER
							NO. 27349

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DATE 05.11.23	TITLE DOOR	REV. D SHEET 2 OF 7 SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.01*[Signature]*



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

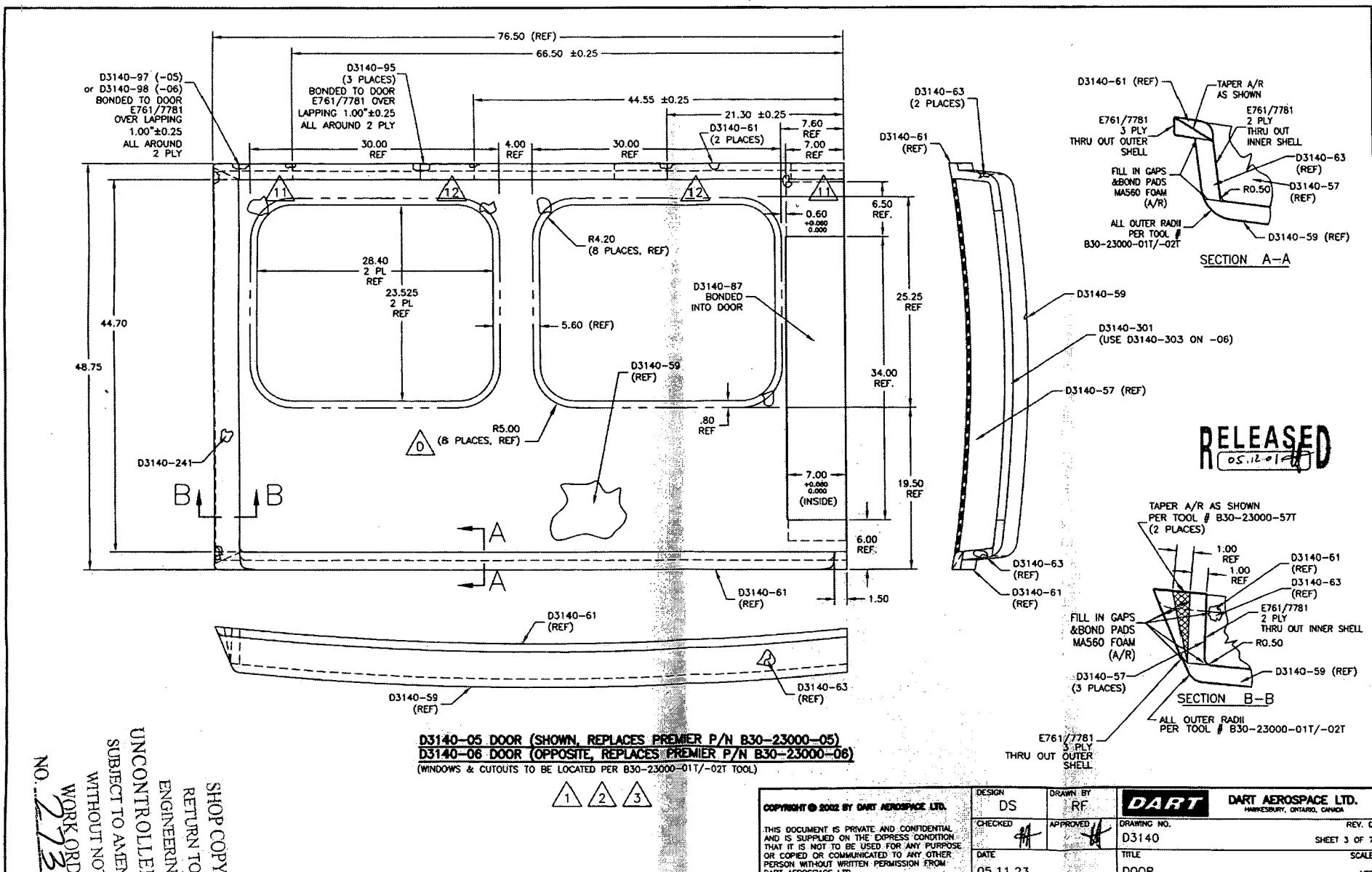


RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

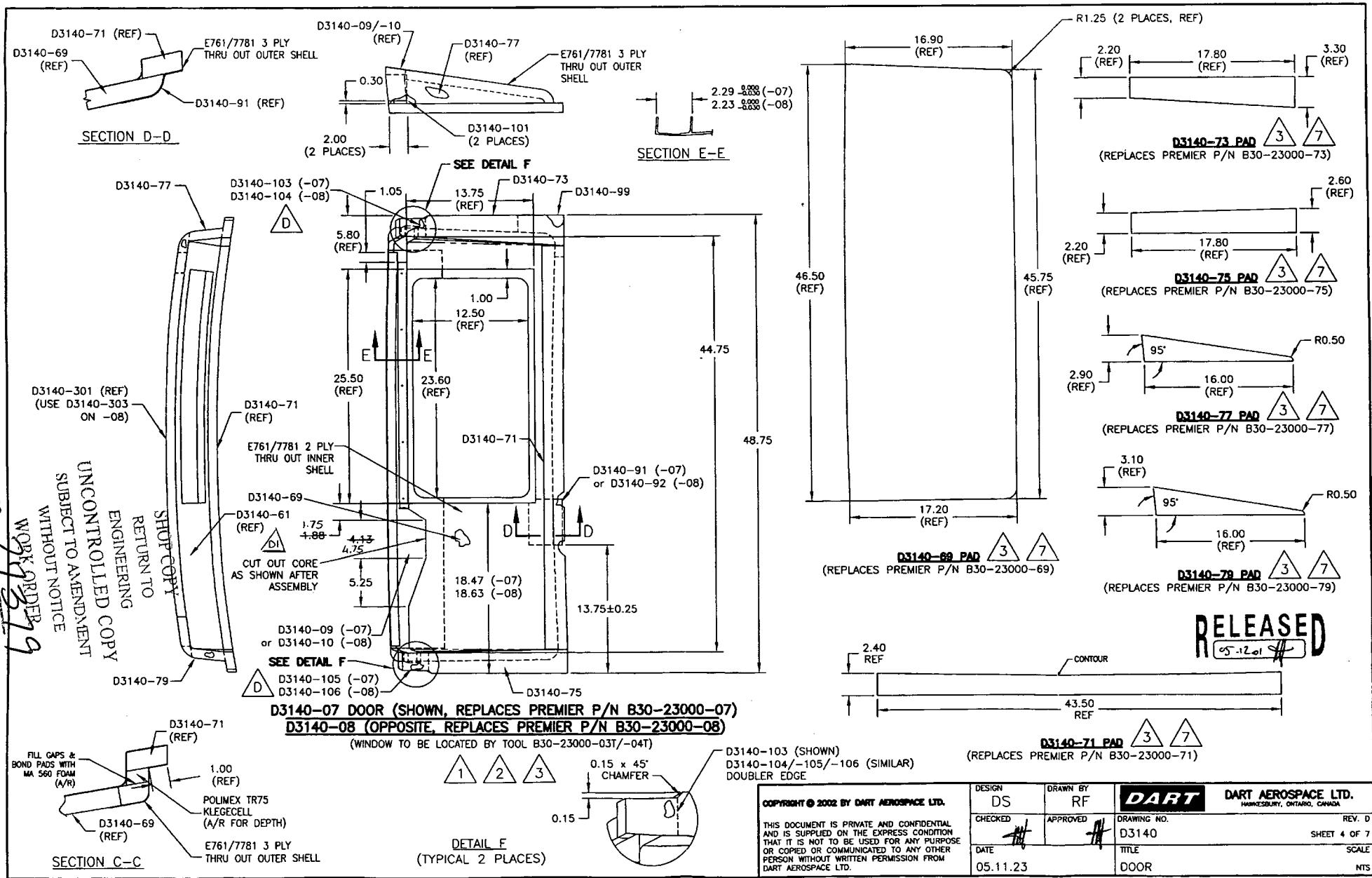
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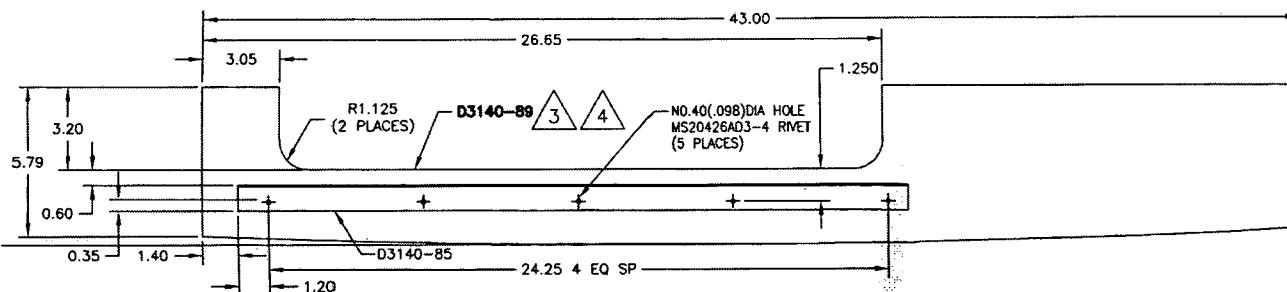
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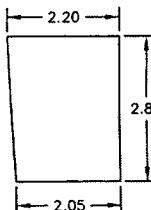


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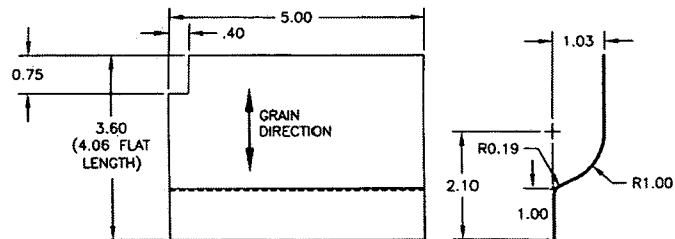




D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)

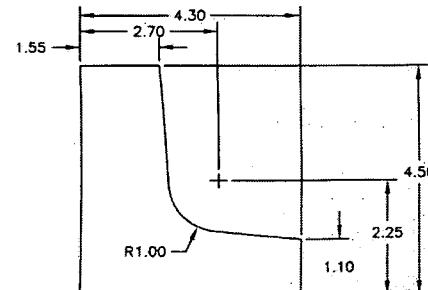


D3140-101 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-101)

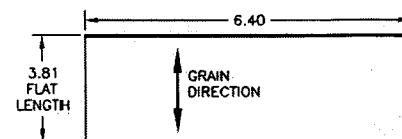


D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-91 DOUBLER 4
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

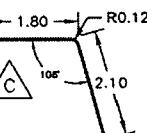
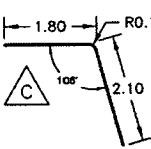


D3140-98 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-99)



D3140-95 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-95)

RELEASED
 05.12.01



BEND DETAIL

D3140-97 DOUBLER 4
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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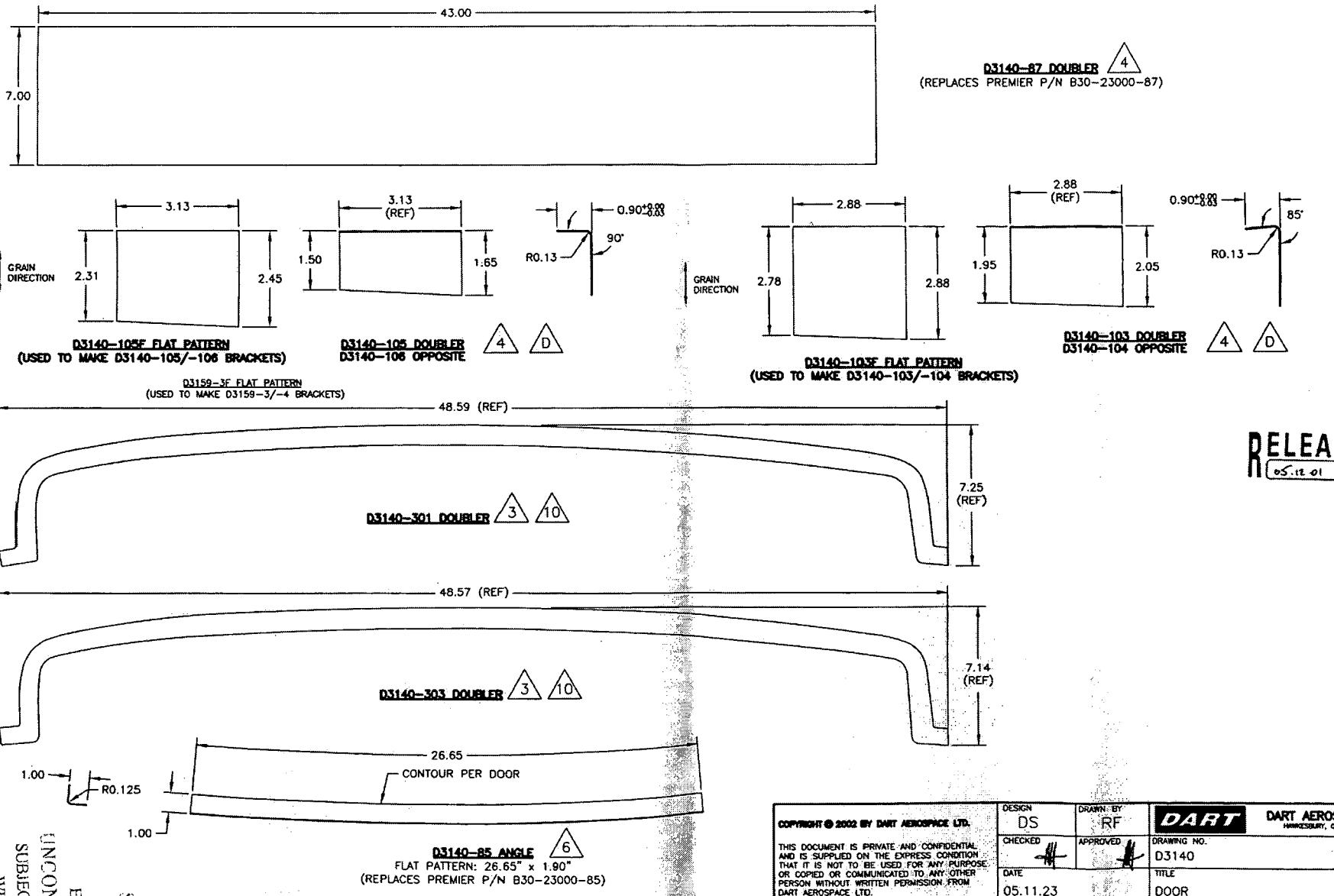
SHEET 5 OF 7

DATE
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TITLE
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 NTS

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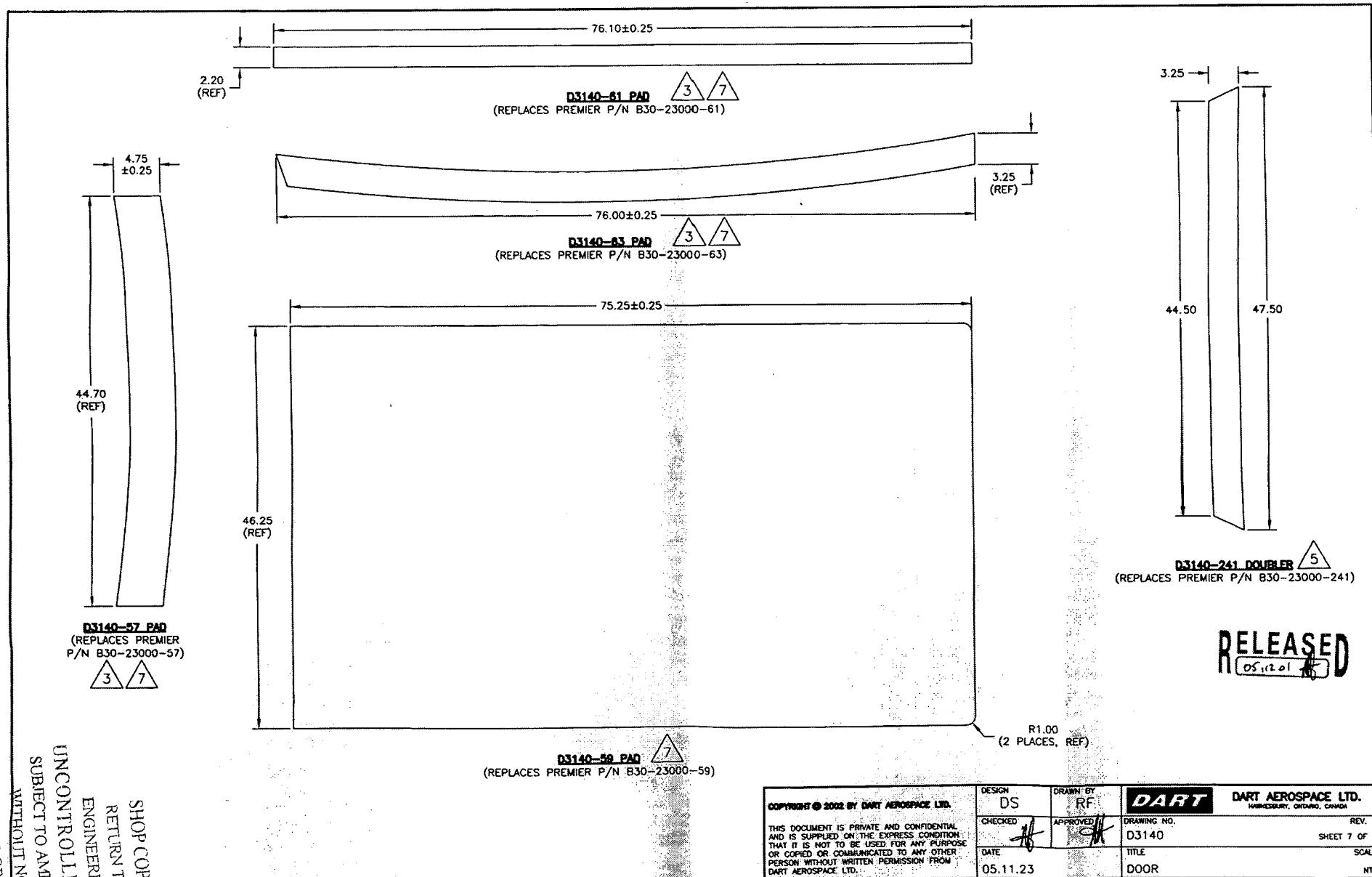
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DART AEROSPACE LTD	Work Order:	07379
Description:	Part Number:	3140 91
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	M.M.	Audited by:		Prototype Approval:	
Date:	06.06.08	Date:	 06.06.12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	